

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020092**Date Inspected:** 21-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#19

ZPMC personnel performing Grinding of after back gouged locations for further critical repair weld of SB106 east and west.

ABF QC NDT MT personnel performing MT on Bike path BK004A-014 sole plate fillet welds is in progress.

ABF QC NDT UT personnel performing UT on suspender bracket SB104 West (R6) CWR locations is in progress.

This QA inspector performed MT 15% of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as OBG bike path. The weld designations reviewed as follows

BK005A5-002-014,015, 111,024,025,044,045,127,116,064,129,074,075,120,132

BK4A-013

During random in-process visual inspection of OBG Suspender bracket, Caltrans Quality Assurance (QA) Inspector discovered the following issue;

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-ZPMC personnel had performed base metal cutting of X64CA flange and removed from the suspender bracket web, which do not comply with the approved shop drawings.

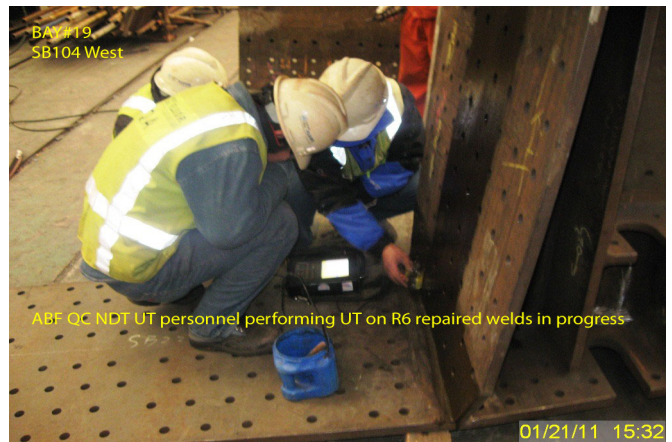
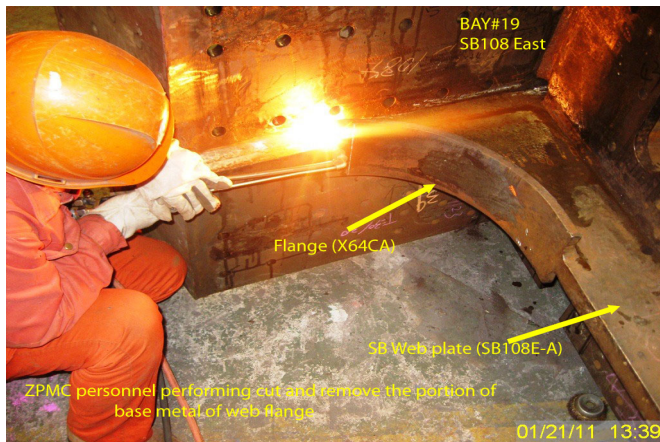
-This cutting was performed without prior approval of the engineer.

- The X64CA flange was welded with the web plate SB108E-A, Complete Joint Penetration (CJP) weld.

For more information please see the Incident report

TL-15_B247_01-21-11_Suspender bracket_BMR_withiout_Engineer_Approval

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

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Inspected By: Kumar,Chadra

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer